

5/13

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	22539
<b>Description:</b> Bushing	<b>Part Number:</b>	D2806-1
<b>Dwg:</b> D2806 rev. A	<b>Qty:</b>	58 58

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Issue W/O	HA	05.02.24	50
2	METAL	Cut blanks: 1.100" long -0.010" +0.030" Material: 6061-T6 (QQ-A-200/8) or (QQ-A-250/11) 1.0" Hex stock M16861 Batch: M17825	CP	05/03/10	58
3	HAAS	Machine as per folio FA105	ER	05/03/10	58
4	QC	Inspect Level 2	CP	05/03/10	58
5	QC	Inspect Level 8	EC	05.03.10	58
6	METAL	<del>Tumble</del> & Deburr	SB	05/03/28	58
7	QC	Inspect Level 5	2	05-03-28	58
8	FINISHING	Chemical conversion coat per QSI 005 Acid etch & Alodine 00-11-13 EC 00-11-13	J.G	05/03/28	58
9	STORES	Identify and stock	CD	05/03/28	58
10	EXPEDITING	Close W/O Cost / part: 1.16 545 05/03/29 (58) 1.50	HA	05.04.05	58

Rev	Date	Change	Revised By	Approved
A	00.11.13	New Issue	EC	HA

RELEASED

EC 00.11.13

UNDER REVIEW

02.06.22/HA

CANCEL # 04.21.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

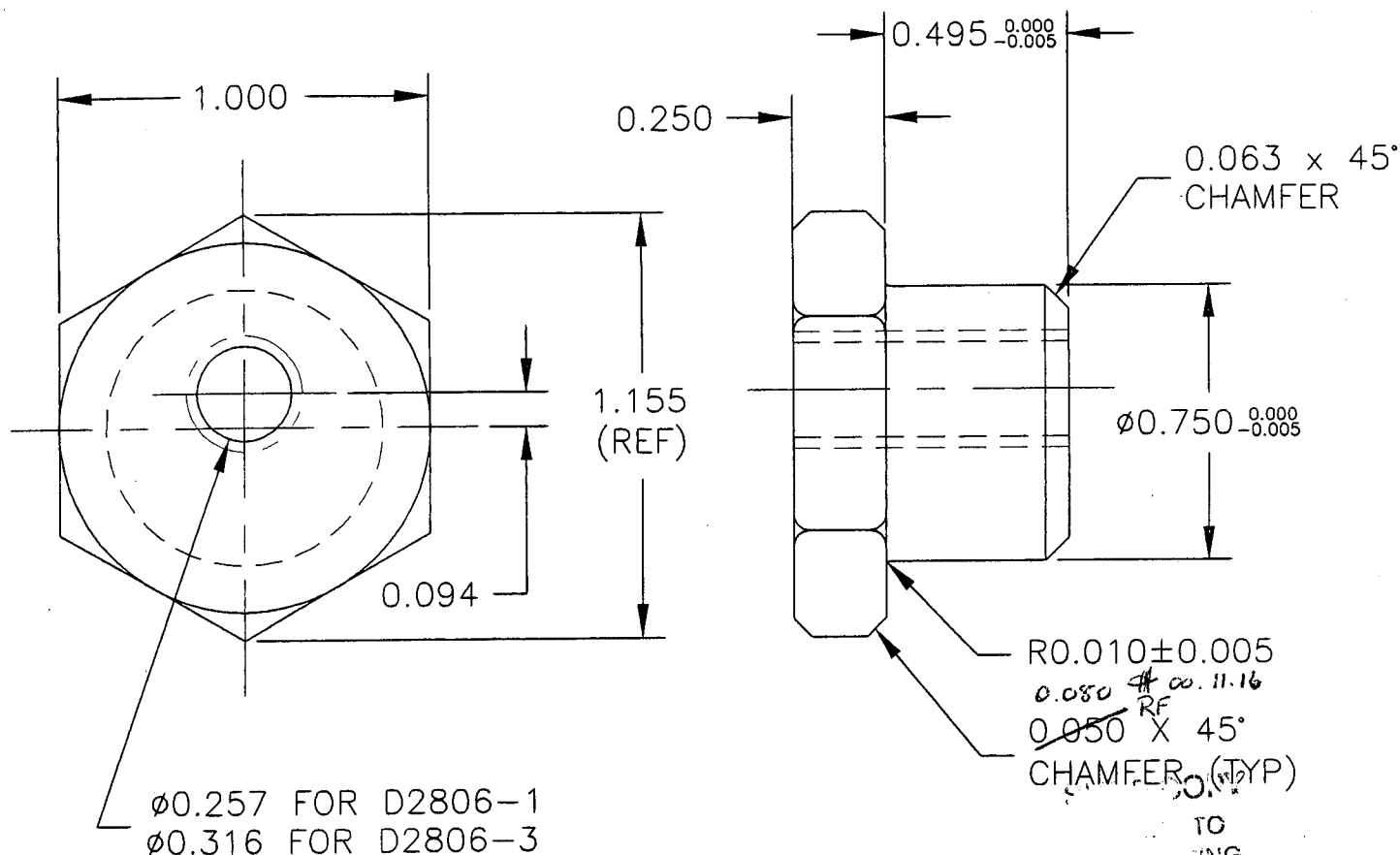
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_





DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2806	REV. A SHEET 1 OF 1
DATE 00.11.08		TITLE BUSHING	SCALE 2:1
A	00.11.08	NEW ISSUE	

RELEASED  
00.11.13 #



D2806-1 (DRILL  $\phi 0.257$  HOLE)  
D2806-3 (DRILL  $\phi 0.316$  HOLE)

TO  
LING  
ED COPY  
ENDMENT  
NOTICE

ORDER  
NO. 22539

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Feb 23, 2005  
02:12 pm

Work Order No : 0022539  
Project Name : D2806-1  
Project For : WK513  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2806-1  
Description : Bushing  
Manufactured : Yes  
Amount Req'd : 50  
Amount Done : 0  
Start Date : 02-23-05  
Est Finish Date : 03-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00